

Page 1

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 163444

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163444

Page 2

Item ID: D412-698-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Support - V Block

Start Date: 6/27/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/6/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130	Packaging					2	DAS 28 9-89		JUL 24 2017
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-015 Location: FG022								
140	QC21- Final Inspection - Work Order Release	0.00							
140							DAS 21 9-89		JUL 24 2017
QC	Memo	0.20							
Quality Control									

JUL 24 2017

21
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 163444

163444

Parent Item: D412-698-015

D412-698-015

Parent Item Name: Door Support - V Block

Start Date: 6/27/2017

Required Date: 7/6/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C Removed Manufacturing 06-01-25 JLM
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3200-1 *D3200-1* Door Post/Block		Manufactured	No			110	Each	11.0000	2	4			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST022		11							
				156307		11				4			
D3200-3 *D3200-3* Door Wedge		Manufactured	No			110	Each	17.0000	2	4			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST023		17							
				155563		17				4			
D3201-1 *D3201-1* Doubler		Manufactured	No			110	Each	12.0000	2	4			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST023		12							
				156264		4				4			
				158431		2				2x			
				162900		6				2x			
D3201-3 *D3201-3* Angle		Manufactured	No			110	Each	6.0000	1	2			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST023		6							
				140937		3				2			
				158432		3							

JUL 24 2017

JUL 24 2017

JUL 24 2017

JUL 24 2017

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
11111111 11111111								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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Work Order ID: 163444

163444

Parent Item: D412-698-015

D412-698-015

Parent Item Name: Door Support - V Block

Start Date: 6/27/2017

Required Date: 7/6/2017

Start Qty: 2.00

Required Qty: 2.00

D3201-4

Manufactured No

110

Each

7.0000

2

D3201-4

Angle

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST023

7

155564

3

158430

4

2

JUL 24 2017

MS21042L3

Purchased No

110

Each

1,475.000

24

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

FP001

79

m135945

79

GA

394

m134360

102

M136665

292

OVER007

500

m134360

0

m137886

500

ST303

502

m137680

502

24

JUL 24 2017

MS24693-S277

Purchased No

110

Each

90.0000

24

MS24693-S277

Screw

**

Location

Loc Qty

Loc Code

ST286

90

M136851

40

M137178

50

24

JUL 24 2017

DAS
28
9-89

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Shop Packet Print

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Work Order ID: 163444

163444

Parent Item: D412-698-015

D412-698-015

Parent Item Name: Door Support - V Block

Start Date: 6/27/2017

Required Date: 7/6/2017

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0332J

Purchased

No

110

Each

920.0000

12

24

NAS1149D0332.J

Washer

**



DAS
28
9-89

Location

Loc Qty

Loc Code

FP

211

m136015

8

m137075

203

GA

272

m136643

272

ST264

437

m136015

0

m137736

437

M137963

24

JUL 24 2017

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Work Order ID 163444

163444

Page 1

Tuesday, June 27, 2017 1:12:08 PM

Item ID: D412-698-015 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Door Support - V Block
 Start Date: 6/27/2017 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 7/6/2017 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: JUN 28 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	JUL 19 2017							
IIN D412-698	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-698-015 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.06							
Quality Control									

DAS
5
9-89

2

JUL 21 2017



Transport Canada

Transports Canada

Department of Transport

Supplemental Type Certificate

This approval is issued to:

Eagle Copters Ltd.
823 McTavish Road N.E.
Calgary, Alberta
Canada T2E 7G9

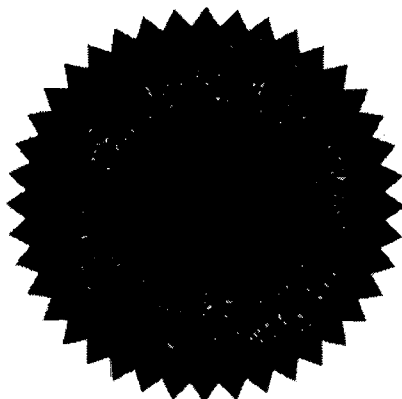
Number: SH92-43**Issue No.:** 5**Approval Date:** August 26, 1992**Issue Date:** September 14, 2007**Responsible Office:**

Prairie and Northern

Aircraft/Engine Type or Model:BELL 204B, 205A, 205A-1, 205B, 212, 214B, 214B-1, 412,
412 CF, 412 EP**Canadian Type Certificate or Equivalent:**BELL 205B H-104
BELL 214B, 214B-1 H-80
BELL 212, 412, 412 CF, 412 EP H-86
BELL 204B, 205A, 205A-1 H1SW**Description of Type Design Change:**Serviceability Kit: Aux Cowl latches, cockpit door wear pads,
cabin door handle, sliding door roller system and automatic
door opener kit**Installation/Operating Data,
Required Equipment and Limitations:****Configuration 1:**Installation of Serviceability Kit to be done in accordance with DOT approved Aero Design Ltd.,
Document Control List A-85-DCL1, Revision 1, dated 27 January 1997, or later approved Revision.**Configuration 2:**Installation of Door Modification Kits to be done in accordance with Transport Canada (TC) approved
Dart Aerospace Ltd. Installation Instructions IIN-D412-698, Revision D or later TC approved revision.Inspection of Door Modification Kits is to be performed in accordance with Dart Aerospace Ltd.
Instructions for Continued Airworthiness ICA-D412-698, Revision 3 or later TC accepted revision.

-END-

Conditions: This approval is only applicable to the type/model of aeronautical product specified therein.
Prior to incorporating this modification, the installer shall establish that the interrelationship between this
change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the
modified product.




Greg Oucharek
Senior Aircraft Certification Engineer
For Minister of Transport

Canada

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		NAS1149D0332J	WASHER (AN960JD10L)
	2	NAS1149D0516J	WASHER (AN960JD516L)
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW